

Work Order ID 94721

94721

Page 1

December-20-12 8:08:38 AM

Item ID: D3913-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 12/18/12 Start Qty: 2.00

2
2 (5x)

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

PL

Date: 13-01-0

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1- Cut tube as per dwg D3913 2- Drill hole as per dwg ***one side only*** 3- remove identification marks and deburr | | | | | | | | |
| 110 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *110* QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *120* Packaging | <i>Bucket coll</i> Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

5x *SL 13.05.23*

*DAS
24
13.5.22*

5x

5x *SL 13.05.23*

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | | | | | | | | |
|--|-------------------|---------------------------------|--------------------------------|---|------------------------------------|------------------------------------|--|---|------------------------------------|------------------------------------|------------------------------------|--|------------------------------------|---|--|---|--------------------------------------|----------------------------------|--------------------------------|
| Part No. _____ | Work Order Update | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> | Quality <input type="checkbox"/> | Other <input type="checkbox"/> |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | | | |

Work Order ID 94721

94721

Page 2

December-20-12 8:08:38 AM

Item ID: D3913-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 12/18/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/11/13 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Quality Control

Memo

0.00

MC 13-05-23

MF
13-5-22

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|------------------------------|--|--|------------------------------------|---|---|--------------------------------------|--------------------|--|-------------|--------------|--------------|
| Part No. _____ | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | |
| NCR No. _____ | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | |
| | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear | | | | General | | | | | | | |
| Bending | Bend | Grain | Ovalized | Pressure/Forced | | | | | | | |
| Centre Not Concentric to O/S | BOM/Route | Hardware | Over/Under tolerance | Temperature/Cure | | | | | | | |
| Cracks | Broken/Damaged | Inspection Incomplete | Part Incorrect | Weld | | | | | | | |
| Crushed/Crimped | Burrs | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled | | | | | | | |
| Cuffs | Contamination | Maintenance | Part Moved | | | | | | | | |
| Heat Treat | Countersink | Mislabeled | Positioned Wrong | | | | | | | | |
| Inspection Strip in Tube | Cut Too Short | Misread | Power Loss/Surge | | | | | | | | |
| Ripples in Bend | Drill Holes | Offset | Other | | | | | | | | |
| Torque Waves in Extrusion | Drawing | Out of Calibration | | | | | | | | | |
| Turning Sequence | Finish | Out of Sequence | | | | | | | | | |
| Wave/Twist in Tube | Folio | Outside Dimensions | | | | | | | | | |

Picklist Print

December-20-12 8:08:38 AM

Page 1

Work Order ID: 94721

Parent Item: D3913-1

Parent Item Name: Rib

Start Date: 12/18/12

Required Date: 1/11/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
DD 10.04.12 verified by:EC IPP Rev:C 11.01.18 chg qc5 to 6 DD verf:EC
IPP Rev:B add drill one side only

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.049 304 SQ Tube .75x.75x.049W | Purchased | No | | | | 100 | f | 905.1312 | 8 | 16.842105 | 486t 514 | | |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT017 | 2.0156214 | |
| 121898 | 2.0156214 | |
| WA006 | 903.1155859 | |
| 122201 | 0.1626 | |
| 122425 | 39.0000000 | |
| 122666 | 0.7293 | |
| 122710 | 20.5 | |
| 123219 | 289.5 | |
| 123484 | 553.223686 | |

11625375 →
84 13-05-23

NCR: Yes / No

DQA: Date: _____

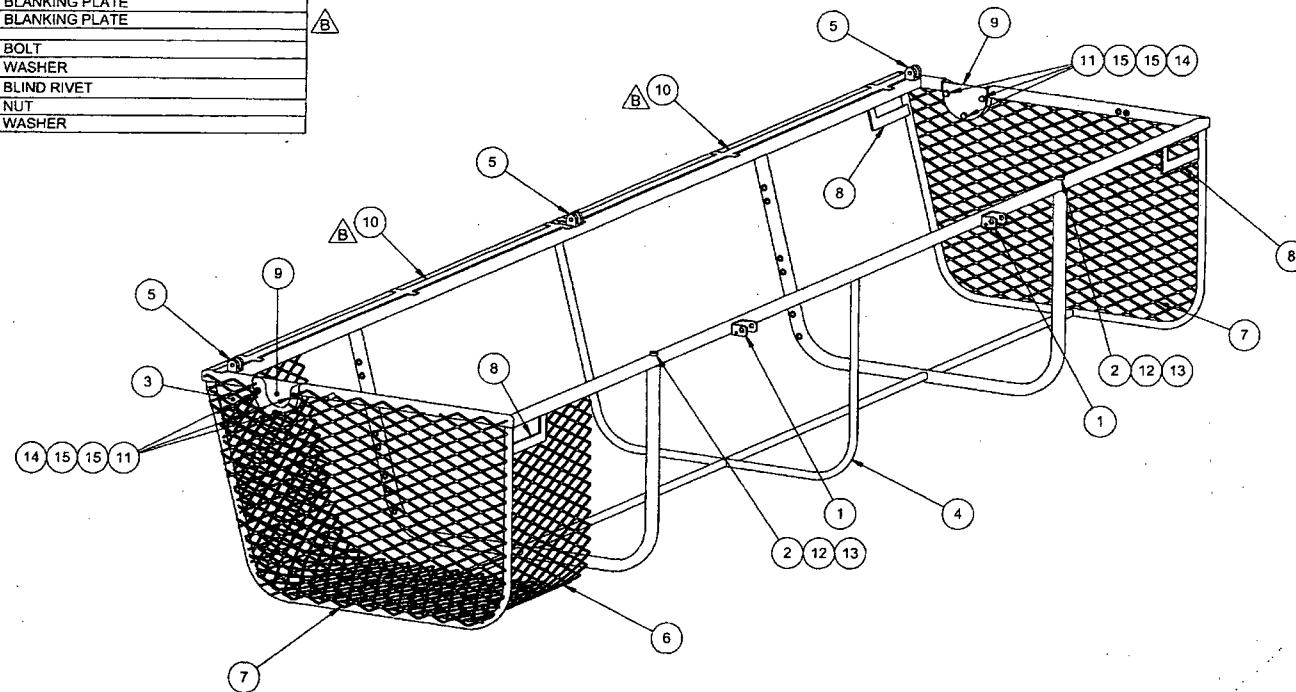
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

| Work Order: _____ Part No. _____ NCR No. _____ | | | | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | | AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | | | | | | | |
|--|--|------|------|---|---|---|---|--------------------|--|-------------|--------------|--------------|--|--|---|--|
| | | | | | | | | | | | | | | | | |
| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | | Initial Chief Eng | Action Description | | Sign & Date | Verification | QC Inspector | | | | |
| Doc/Data | | | | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | | | | | | |
| Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube | | | | General Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> | | | Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> | | | | | | Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> | | Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/> | |

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|--------------------------------|
| | X | D3913-041 | LONG BASKET BASE ASSY (350) |
| 1 | 2 | D2581 | MOUNTING BRACKET |
| 2 | 2 | D2931 | BUMPER |
| 3 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 4 | 1 | D3913-101 | TUBULAR ASSY (350 LONG BASKET) |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-1 | MESH (350 BASKET LONG BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 2 | D4672-1 | BLANKING PLATE |
| 11 | 6 | AN3-10A | BOLT |
| 12 | 2 | AN960J08 | WASHER |
| 13 | 2 | MS20600AD4W3 | BLIND RIVET |
| 14 | 6 | MS21042L3 | NUT |
| 15 | 12 | NAS1149F0332P | WASHER |

94172
P/B 01-8



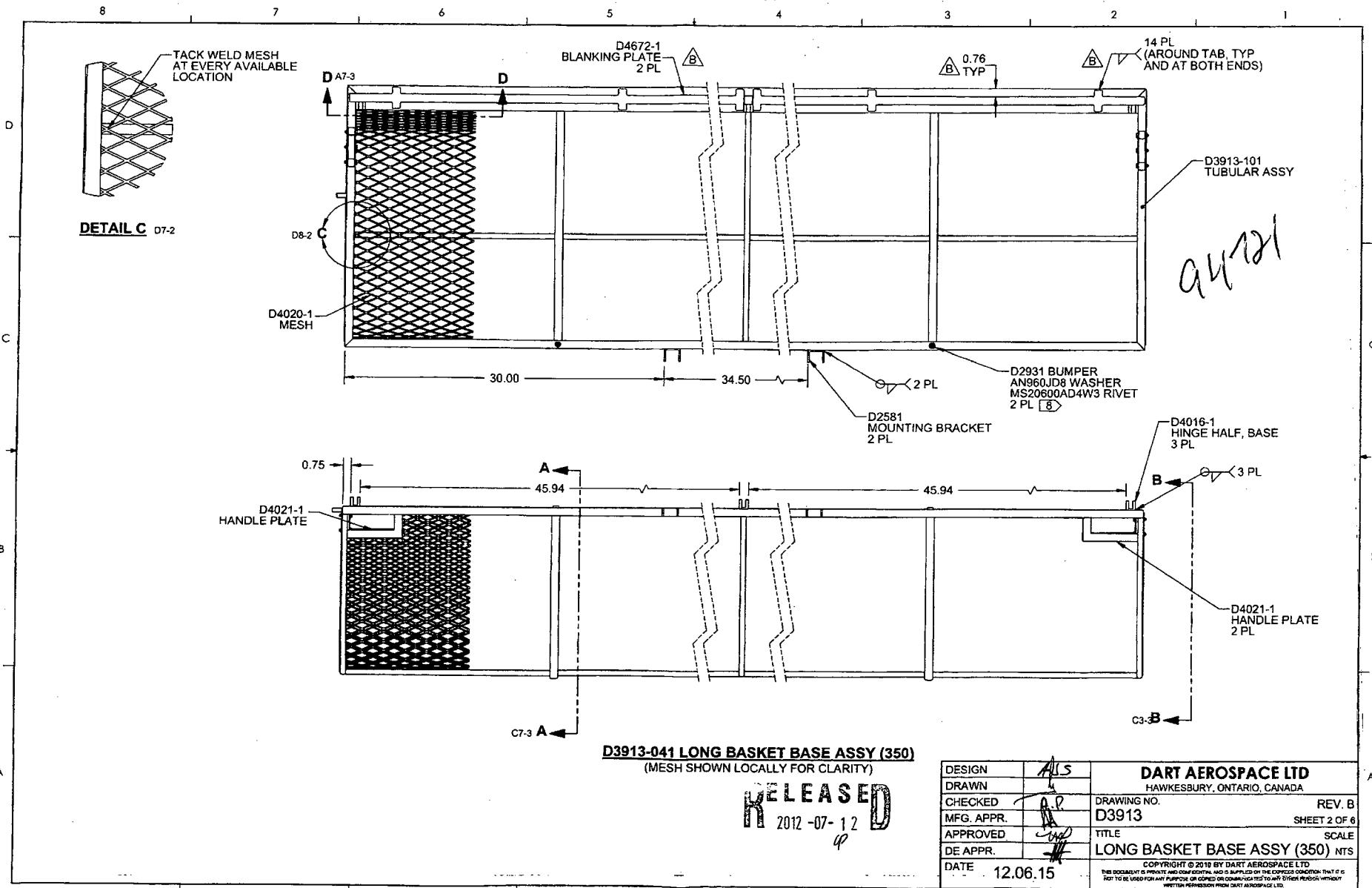
D3913-041 LONG BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

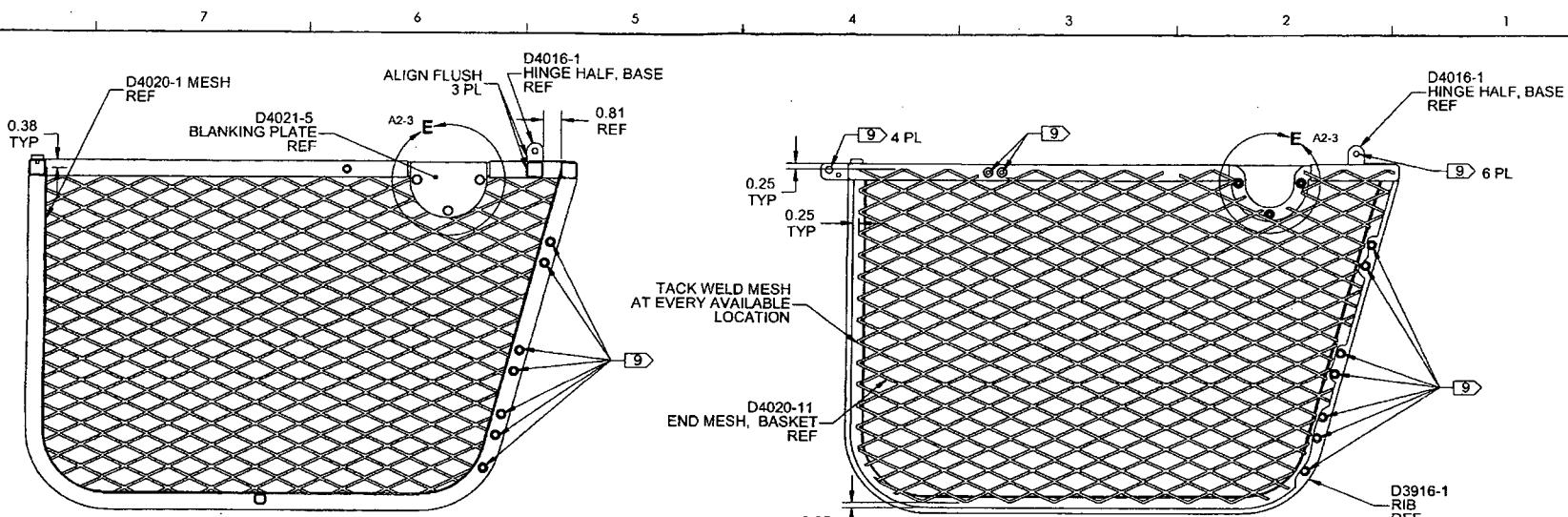
NOTES:
 1) MATERIAL: N/A
 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: NONE
 7) WEIGHT: 43.9 lbs APPROX
 8) INSTALL AFTER FINISH
 9) MASK HOLES PRIOR TO POWDER COAT
 10) WELD PER DART QSI 004

RELEASED
2012-07-12
(P) ECN 12-610

| | | | |
|---------------------------------|--|-----------------------------|----------|
| B | ADD D4672-1 (ZN C4-1, C6-1, D2-2, D2-3, & D5-2). | MB | 12.06.15 |
| A | REASON: PAR12-197. | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | 145 | DART AEROSPACE LTD | |
| DRAWN | 145 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AP | REV. B | |
| MFG. APPR. | | DRAWING NO. D3913 | |
| APPROVED | | SHEET 1 OF 6 | |
| DE APPR. | | TITLE | |
| DATE | 12.06.15 | SCALE | |
| LONG BASKET BASE ASSY (350) NTS | | | |

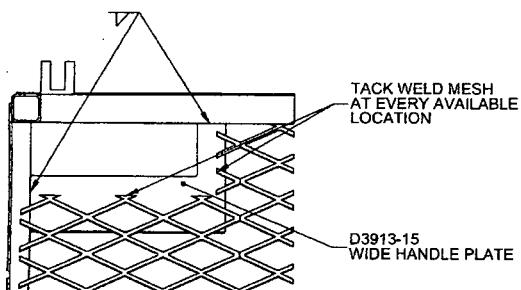
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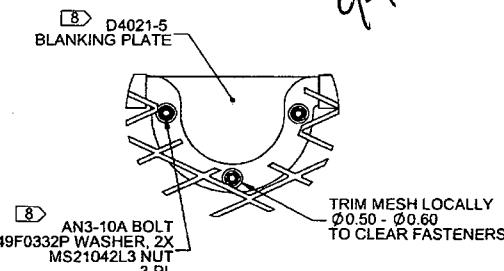


SECTION A-A A5-2

VIEW B-B A2-2



SECTION D-D D6-2
TYPICAL FOR ALL
HANDLE PLATES



DETAIL E D2-3
D6-3

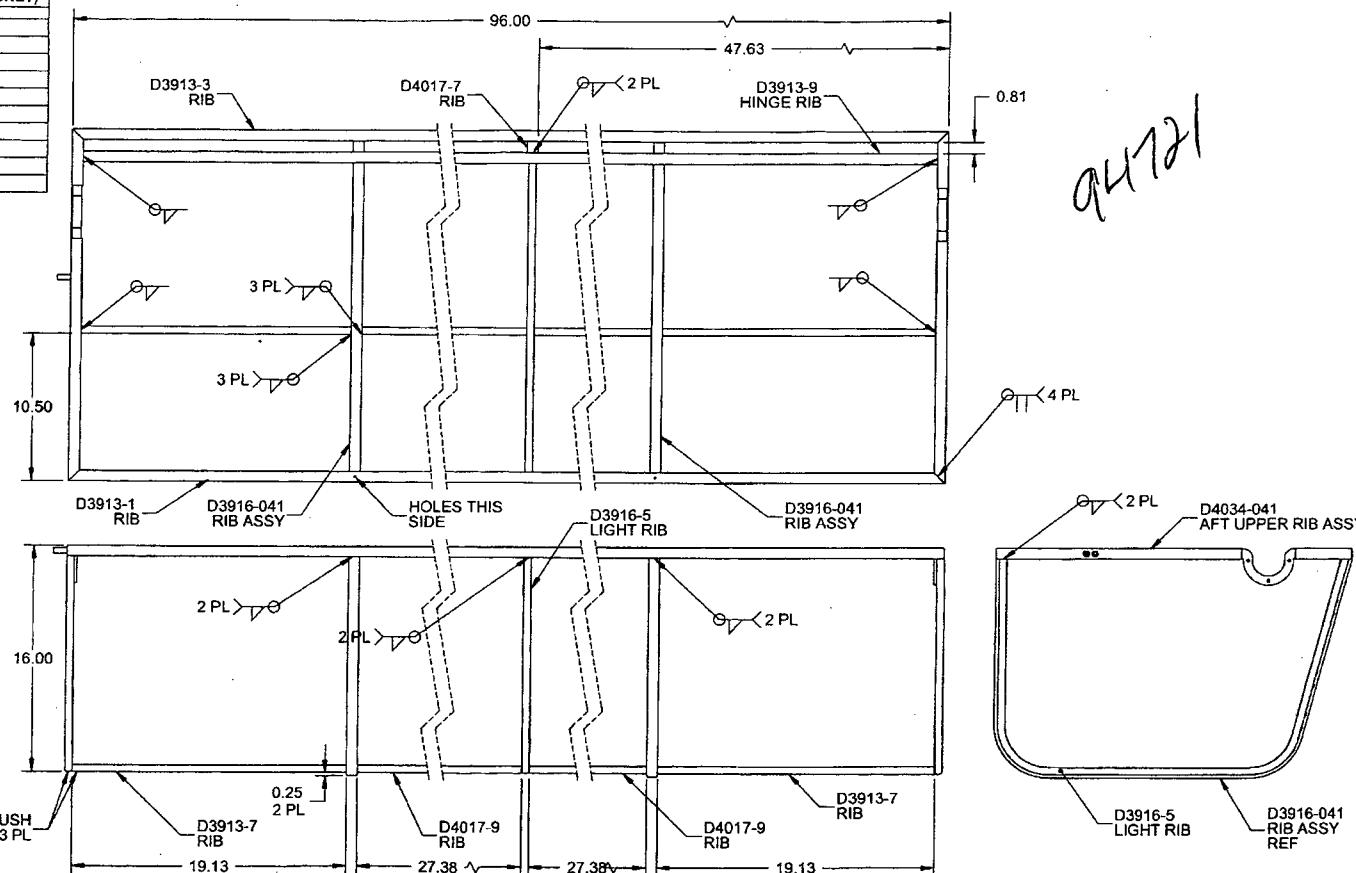
RELEASED
R 2012-07-12
1P

| | | |
|------------|----------|---------------------------------|
| DESIGN | 135 | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | REV. B |
| MFG. APPR. | | D3913 |
| APPROVED | | SHEET 3 OF 6 |
| DE APPR. | | TITLE |
| DATE | 12.06.15 | SCALE |
| | | LONG BASKET BASE ASSY (350) NTS |

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8 7 6 5 4 3 2 1

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|--------------------------------|
| | X | D3913-101 | TUBULAR ASSY (350 LONG BASKET) |
| 1 | 1 | D3913-1 | RIB |
| 2 | 1 | D3913-3 | RIB |
| 3 | 2 | D3913-7 | RIB |
| 4 | 1 | D3913-9 | HINGE RIB |
| 5 | 3 | D3916-5 | LIGHT RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D4017-7 | RIB |
| 8 | 2 | D4017-9 | RIB |
| 9 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 10 | 1 | D4034-043 | FWD UPPER RIB ASSY |



8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 22.53 lbs
 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3913-101
 9) WELD PER DART QSI 004

RELEASED
2012-07-12
q

| | | | |
|------------|----------|---------------------------------|--------------|
| DESIGN | AIS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | A.P. | DRAWING NO. | REV. B |
| MFG. APPR. | | D3913 | SHEET 4 OF 6 |
| APPROVED | | TITLE | |
| DE APPR. | | SCALE | |
| DATE | 12.06.15 | LONG BASKET BASE ASSY (350) NTS | |

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